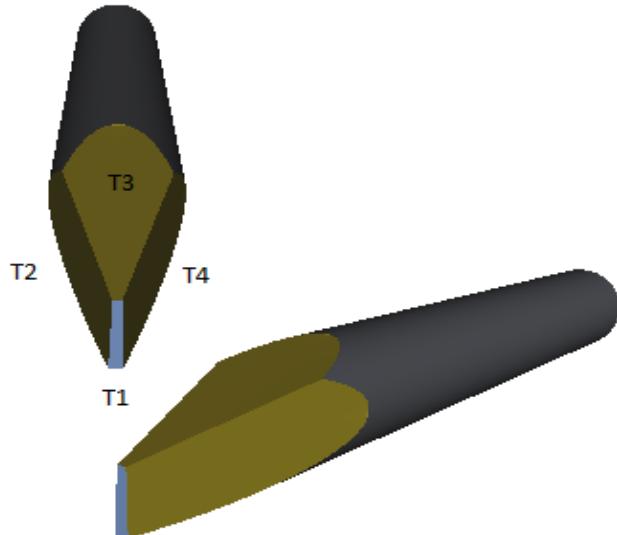


Wire bond tool Ø1.585

A30-200

Wire bond tools are ground with application number A02. Different layers define the shape of each face. In this case, there are three individually layer one for tooth 1, tooth 2+4 and tooth 3.

To reach a high precision, all faces are preground with several hundredths overmeasure and are finished with a polish wheel.



1. Cycletime for Production

Workpiece:	E1011-003-FMZ, diameter 1/16", 4 faces Material CARBIDE						
Operations	Probe	Pre T1	Pre T3	Fin T1	Fin T3	Pre T2+4	Fin T2+4
Feed [mm/Min]	2000	30	60	40	40	60	40
Power [kW]		4	3	2	2	2	3
Cutting speed [m/s]		24	24	22	22	24	22
Used wheels							
Grinding time [s]	33	23	21	18	21	30	40
Total cycle time	3 Min 06						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	11V9 Ø100 D76
2	11V9 Ø75 D46



1

2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories:

Responsible engineer: KIG 27.11.2013

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TECHNOLOGY
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